

shp 22/09

Date: Monday, 18/08/2008 10:27:05 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : N1 GEARBOX ACCESS PANEL KIT
 Job Number : 41289
 Estimate Number : 12505
 P.O. Number :
 This Issue : 18/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D412705017
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3255 REV B
 Previous Run : 40858 Drawing Revision : B
 Material :
 Due Date : 05/09/2008 Qty: 43 Um: Each
 Written By :
 Checked & Approved By : JLD 08.8.18
 Comment : Est Rev:C Removed Manufacturing 06-08-02 JLM
 Est Rev:D ECN 1052 07-11-06 DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08.8.26



Comment: Photocopy bluefile & type labels per PPPD412-705-017 CHG001

S. 08/08/12

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0 D3255041 Access Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Access Panel Assembly
 Batch: 40903

4.0 D3255042 Access Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Access Panel Assembly
 Batch: 40904

5.0 AN3C3A Bolt



Comment: Qty.: 30.0000 Each(s)/Unit Total: 60.0000 Each(s)
 Bolt
 Batch: 1169297 + 90

New Batch
 8/11/15

BY

510

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 41289

Part Number: D412705017

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20427M33

Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total: 72.0000 Each(s) ~~42~~ 6X
Rivet
Batch: M108473 M108521 SD

7.0

MS21060L3K

Nut Plate



Comment: Qty.: 18.0000 Each(s)/Unit Total: 36.0000 Each(s)
Nut Plate
Batch: M108986 x6 M109297 x3 SD

8.0

MS932109

Washer



Comment: Qty.: 30.0000 Each(s)/Unit Total: 60.0000 Each(s)
Washer
Batch: M108986 x83 M109299 x6 8/9/15 SD

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-705-017

Location: A

PPP Rev: A

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.09.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

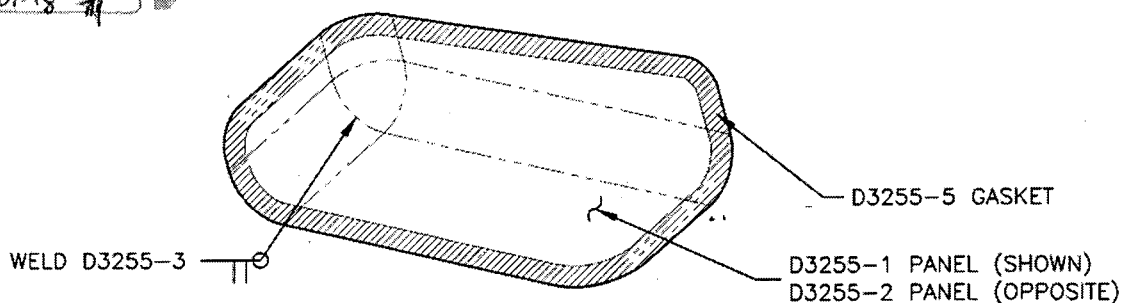
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

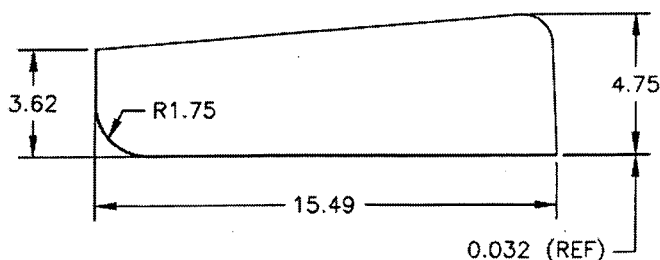
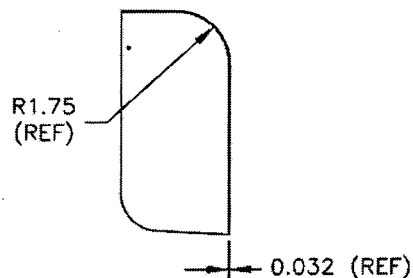
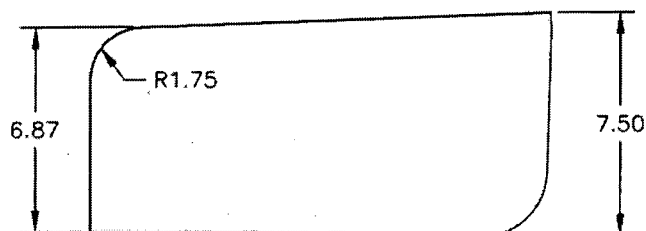


DESIGN R#	DRAWN BY R#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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WITHOUT NOTICE
WORK ORDER

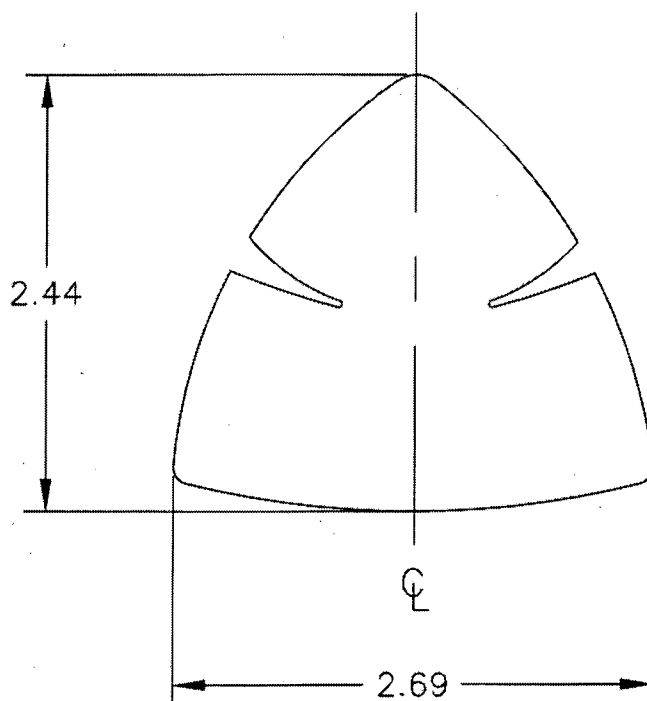
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DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED JF	DRAWING NO. D3255	REV. 8 SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05-01-18 #



D3255-3 CAP
FORM TO FIT D3155-1/-2

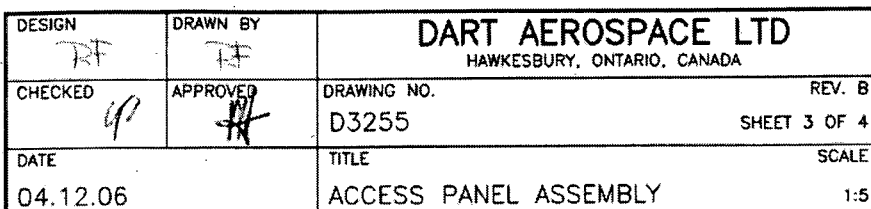
D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

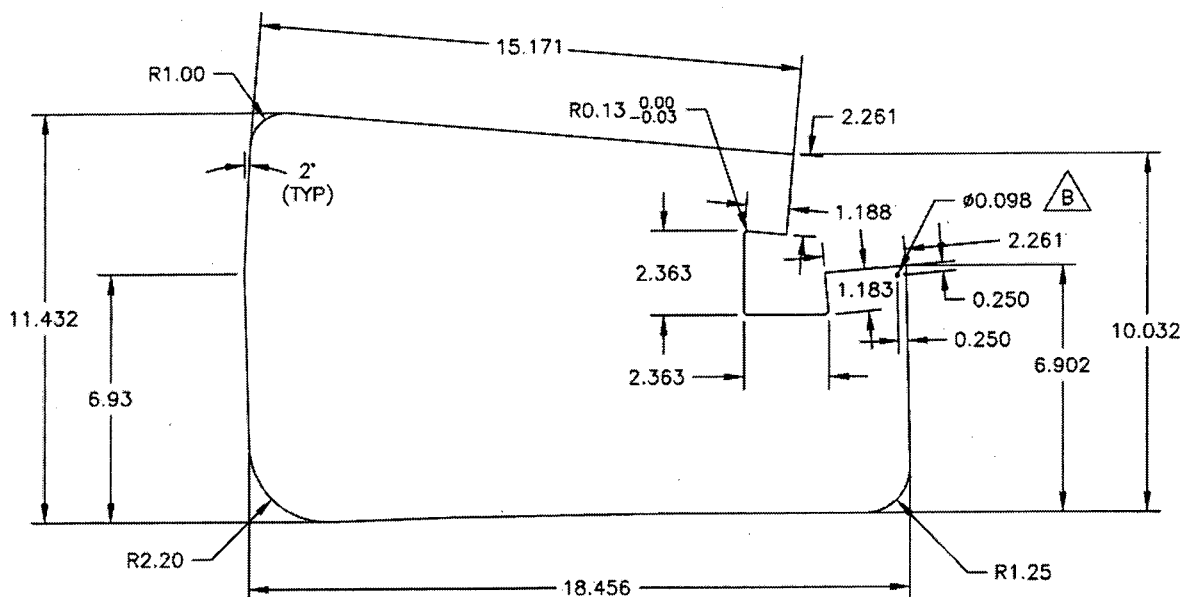
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RELEASED
05-01-18



D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010 UN

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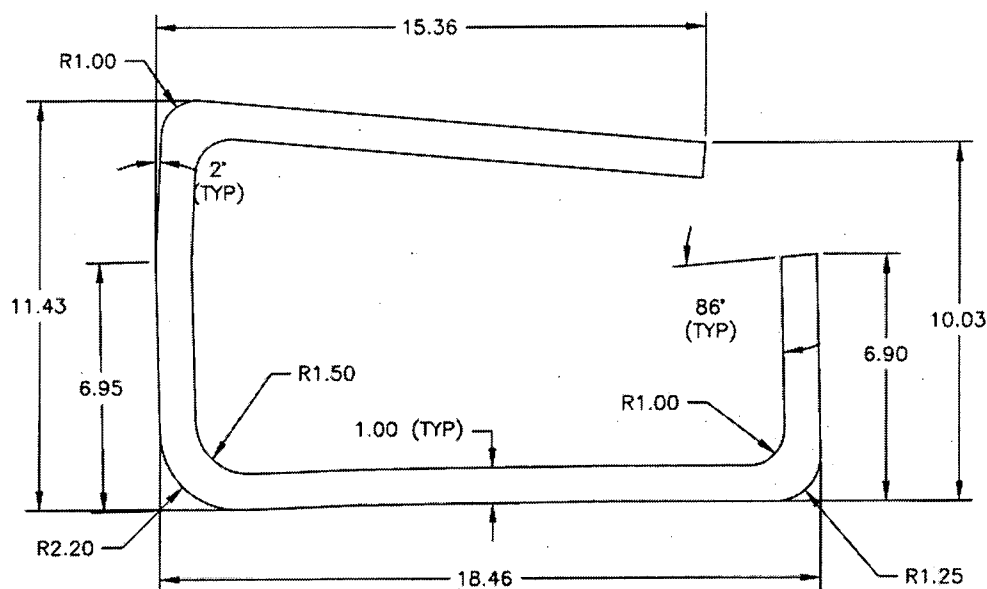
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DESIGN JH	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED JH	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18 JH



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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